July-11-13 12:58:35 PM

Item	ID:
,	

647.4501

Accept

N900040100 Setup Start, *NS1*

NS2

Revision ID: Item Name:

Cutter Assembly

Start Date: 7/11/13 Required Date: 7/25/13

Start Qty: 2.00

Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MUS Date: 13-07-11 Tooling: QC: _____ Date: ____ SPC (Y/N):

Date:

Run

NIP2

								1 7	
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.4500	N/C								
110	Pick Kit	0.00							7
110 Packaging	Мето	0.00	13-07-	- 1/					

120

120

Small Fab Small Fab

0.00

0.00

A 13-07-11

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: 125174 exp. date: 13/11

130

QC5- Inspect part completeness to step on W/O

130

Memo

Memo

Quality Control

DQA:	WORK ORDER NON-CONFORMANCE / UPDATE												DART	
QA Closed:			Date:			WORK ORDER NON-			MINIANCE / OF		W	ork Order up	date only	AEROSPACE
Mark Orda		1				DISPOSITION				AGAINST	DE	PARTMENT	PROCESS	
Work Orde	:r: -	-		-	—	Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	lo					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality
1 diti	٠٠.	r				Use-as-is			noforming	Finishing		1	e/Packaging	Other
NCR N	10.					Suspected Unapproved			Large Fab	Composite		1100,0101	1 0 1	
	•											·	Supplier	
Root					Desci	ription of work order update	- 1	nitial	Action			Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre	_													
Material		i												
Operator	_	l												
Offset/Setup														
Process														
Supplier														
Training						•						}		
Transport														
Unapproved							<u> </u>							
					·		FAI	ULT CA	regory					
Landi						General]	N		$\overline{}$	10		70/54
	-	Bending		_ • ! _		Bend BOM (Boute	⊢		Program		┝	Outside Dim	 	Pressure/Forced
		Centre No	ot Concer	itric	-	BOM/Route	⊢	Grain			⊢	Over/Under	—	Set-up
	-	Crimon /Vin	مامداتا/ باد	Maria	-	Broken/Damage/Defect	┝	Hardwa			\vdash	Part Incorred		Temperature/Cure
		Crimp/Kir Cuffs	ik/vibble	/ wave	-	Burrs	\vdash	1	ion Incomplete/Und		⊢	Part Lost/Mi	221118	Weld Wrong Stock Pulled
	_	Crushing				Contamination Countersink	\vdash		tions Incomplete/U	liciedi	\vdash	Part Moved Positioned V	\\rong	Tantonik stock Laned
	_	Heat Trea	. .		-	Cut Too Short	\vdash	Misla			\vdash	Power Loss/		Other
	_	1		Tube	\vdash	Drawing	\vdash	Misrea			_	Ti omei rossi	Juige	Tottlei
	Inspection Strip in Tube					Drill Holes	-	Off-set						
		Marks/Chatter Turning Sequence				Finish	\vdash	4	Calibration					
	 	Wave/Tw			<u> </u>	Fit/Function	\vdash	4	Sequence					
		1				1	1	10000						

Quality Control

Memo

July-11-13 12:58:35 PM Item ID: 647.4501 Accept *N900040100* Setup Start *NS1* **Revision ID:** Item Name: Cutter Assembly **Start Date:** 7/11/13 Start Qty: 2.00 Cust Item ID: Required Date: 7/25/13 Req'd Qty: 2.00 **Customer:** Reference: Run Process Plan: _____ Date: ____ Tooling: Approvals: Date: QC: _____ Date: ____ SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Number Stamp Qty 140 Identify as per dwg & Stock Location: 57440 0.00 2x M.W. 13-07-12 *140* Packaging 0.00 Memo Packaging ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV*** 150 QC21- Final Inspection - Work Order Release 0.00 *150* OC 0.00

MLJ 13-07-16 NB-07-14

DQA:	out.												TQ AC*	
			. .			WORK ORDER NON-	-CC	ONFO	RMANCE / U					AEROSPACE
QA Closed:			Date:								Wor	k Order up	date only	
Work Orde	er:					DISPOSITION				AGAINST [DEP.	ARTMENT/	PROCESS	
						Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	lo.					Scrap		1	Machining	Small Fab	┪	Prod	d. Eng. Coor.	Quality
					_	Use-as-is			noforming	Finishing				Other
NCR N	10					Suspected Unapproved		Large Fab Composite					Supplier	
Root					Desci	ription of work order update	į	nitial	Act	ion		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	\perp	Date	Verification	QC Inspector
Design	_	:												
Doc/Data											-			<u> </u>
Equip/Tooling														!
Handling/Pre	_													
Material	_													
Operator	_													
Offset/Setup	_													!
Process	_													j
Supplier	_					•								
Training	_													
Transport	_													1
Unapproved							<u> </u>		50001					
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Landir	ng Gear					General Bend	_	 		Г	一,	n	. Г	つ。
		nding	t Concer	***	-	BOM/Route	┝	1	rogram	-		Outside Dim	<u> </u>	Pressure/Forced
		ntre No icks	Concer	itric		Broken/Damage/Defect	<u> </u>	Grain		-	_	Over/Under	 	Set-up Temperature/Cure
			k/Ripple	Mayo	-	Burrs	\vdash	Hardwa		agualified		Part Incorrec Part Lost/Mis	—	⊣ ` `
	Cut		k) kippie	/ wave	-	Contamination	\vdash	1	ion Incomplete/Ur ions Incomplete/U			Part Moved	- F	Weld
		ushing				Countersink	┢	1	ned/off center	Difficient	_	Positioned W	/rong	Wrong Stock Pulled
	_	at Trea	t			Cut Too Short	\vdash	Mislabe		1	_	Power Loss/S		Other
				Tube		Drawing	\vdash	Misread		L	'	OWEI LUSS/.	Duige _	Totalei
	Inspection Strip in Tube Marks/Chatter			Drill Holes	-	Off-set	•		-					
	_		equence			Finish	\vdash	1	Calibration		-			
						Fit/Function	T	1	Sequence		-		·	<u> </u>
	Wave/Twist in Tube							4						

Picklist Print

July-11-13 12:58:40 PM

Work Order ID: 104453

647.4501

104453 *647 4501*

Parent Item Name: Cutter Assembly

Parent Item:

Start Date: 7/11/13

Required Date: 7/25/13

Start Qty: 2.00

Required Qty: 2.00

IPP REV:A 12.09.19 NEW ISSUE DD VERF:JLM Comments: Replacement Mfg/ Component Item ID/ Bin **Primary** Last Qty on Route Unit of Qty per Kit Total Qty Date Status Item Name Item ID Purch Item Location Location Seq ID Measure Hand Issued Issued Qty 646.9701 Manufactured No 110 Each 47.0000 2 *646 9701* ** 13-07-11 Cutter Sub Assembly Location Loc Qty Loc Code MF 47 89707 7 26 12 92558 2 647.4610 Manufactured No 110 Each 18.0000 2 *647 4610* ** Upper Deflector Location Loc Qty Loc Code MF 16 91289 16 st139g 2 m126249 2 MS21042L08 Purchased No 110 Each 3,511.000 *MS210421 08* ** 13-07-11 Nut Location Loc Qty Loc Code ST315 1511 122141 3 122452 9 122814 500 12390Ó 999 ST505 2000

2000

125445

DQA:			Date:							•				DART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP					AEROSPACE
QA Closed:			Date:								Wo	ork Order up	date only	
Work Orde	r:					DISPOSITION				AGAINST	DEI	PARTMENT	PROCESS	
	··· -					Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality
	-				_	Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging	Other
NCR N	lo. -		· · · · · · · · · · · · · · · · · · ·			Suspected Unapproved		Large Fab Composite					Supplier	
Root					Desci	ription of work order update	1	nitial	itial Action			Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description			Date	Verification	QC Inspector
Design														
Doc/Data	4	İ												
Equip/Tooling	_													
Handling/Pre	_													
Material	_													
Operator	_													
Offset/Setup	_													
Process														
Supplier							1							
Training -	_													
Transport	_													
Unapproved			<u> </u>	L			EAL	III CA	L TEGORY					
Landir		COR				General	FA	OLI CA	IEGORT					
Lanui	$\overline{}$	Bending				Bend] Folio/E	Program			Outside Dim	ensions [Pressure/Forced
		Centre No	nt Concer	ntric	-	BOM/Route	-	Grain	rogram		_	Over/Under	⊢	Set-up
		Cracks	or concer	itire	\vdash	Broken/Damage/Defect		Hardwa	are			Part Incorrec	}	Temperature/Cure
		Crimp/Kin	k/Rinnle	/Wave	\vdash	Burrs	-	4	ion Incomplete/Unc	nualified		Part Lost/Mi	-	Weld
		Cuffs	по парыс	, wave	\vdash	Contamination	-	1 '	tions Incomplete/Ur	`		Part Moved	 _	Wrong Stock Pulled
	-	Crushing			-	Countersink		•	gned/off center			Positioned V		
	Crushing Heat Treat				Cut Too Short	 	Mislabe	-		<u> </u>	Power Loss/	· ·	Other	
		Inspection		Tube		Drawing		Misrea		i	Ь	1	<u> </u>	
	_	Marks/Ch	•			Drill Holes		Off-set						
	Turning Sequence					Finish		4	Calibration	•				
	Turning Sequence Wave/Twist in Tube					Fit/Function		4	Sequence				······································	

Picklist Print

July-11-13 12:58:40 PM

Work Order ID: 104453

Parent Item:

647.4501

Parent Item Name: Cutter Assembly

104453 *647 4501*

Start Date: 7/11/13

Required Date: 7/25/13

Start Qty: 2.00

Required Qty: 2.00

MS27039-08-19

Purchased

No

110

Each

2,230.000

6 90 13-07-11

MS27039-08-19

Locatio	<u>n</u>	Lo	c Qty	Loc Code
ST307			89	
	123525		89	
ST309			941	
	(25654)		941	
st510			1200	
	124309		1200	
		110	Each	15,989.00

12

NAS1149FN832P

Purchased

No

**

R 9 13-09-11

NAS1149FN832P Washer

Location	Loc Oty	Loc Code	
ST294	5997		
123522	400		
123900	5597		
ST510a	9992		
125268	9992		

DQA:		_ Date:			MODIC ODDED MON	~		2242265 / 145	DATE				*DART
QA Closed:		Date:			WORK ORDER NON-	-CC	JNFOI	RIVIANCE / UF		Wo	ork Order up	date only	AEROSPACE
Work Orde					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
Work Orde	· ·				Rework			Skid-tube	Crosstube			Engineering	
Part N	lo.				Scrap		Machining Small Fab				Pro	Water Jet d. Eng. Coor.	Quality
raitiv				_	Use-as-is			noforming	Finishing	Rec/Store/Packaging			Other
NCR N	lo.				Suspected Unapproved		1110111	Large Fab	Composite		1100,0101	Supplier	
				_				ν Ц	,				
Root				Desci	ription of work order update	i	nitial	Acti	ion		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption		Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process													
Supplier													
Training													
Transport													
Unapproved			1										
						FAI	ULT CA	regory					
Landi	ng Gear				General							_	
	Bending				Bend	L	Folio/F	rogram			Outside Dim	ensions	Pressure/Forced
	Centre N	Not Conce	ntric		BOM/Route	<u> </u>	Grain				Over/Under	tolerance	Set-up
	Cracks			L	Broken/Damage/Defect		Hardwa	re			Part Incorre	ct	Temperature/Cure
	Crimp/K	ink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Un	nqualified	_	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	tions Incomplete/U	Inclear	L	Part Moved		Wrong Stock Pulled
	Crushing			Countersink		Misalig	ned/off center	•	L	Positioned V	Vrong _	_	
	Heat Treat				Cut Too Short		Mislabe	eled		L	Power Loss/	Surge	Other
	Inspection	on Strip in	Tube		Drawing	Misread							
	Marks/C	hatter			Drill Holes		Off-set						
	Turning	Sequence	!		Finish .		Out of	Calibration					
İ	Wave/T	wist in Tul	he		Fit/Function		Out of	Seguence					

NOTES: 1. IDENTIFY IAW MPP-120 2. APPLY F/N 6 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1 & 5 UPON ASSEMBLY SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 104453 MCS 13-07-11 647.4501

	A/R	6	601.2045	RTV. LOCKTITE 598							
	1	5	647.4610	UPPER DEFLECTOR	1						
	3	4	601.1541	LOCKNUT	MS21042L08						
	3	3	601.2765	SCREW	MS27039-0819						
	6	2	601,2764	WASHER	NAS1149FN832P						
	1	ì	646.9701	CUTTER SUB ASSY	UTTER SUB ASSY						
···	$\geq \leq$		647.4501	CUTTER ASSY							
	.4501	FIND	# PART#	DESCRIPTION	MAT'L	SPEC.					
G	ΣΤΥ	<u> </u>		PARTS LIST	PARTS LIST						
	XT ASSY 647.2600	(2)	DRCSEAL DATE NO DA YEL TO 15-00 DEANNE BY CHECKER COUN DEANNES DEANNES APPROVAL ERIAND	2608 TEMPLE H	L INDUSTRI IEIGHTS DR. DA. 92056-3512 (760)						
			ENTERS CHERWISE SPECIFIC		CUTTER ASSY						
			DATENSIONS ARE SECORES TOKERATIONS ARE: 2 PLACE OF COMAIN 1015 3 PLACE OF COMAIN 1015	B 07MZ6	647.4500	₹₽V. N/C					

DQA:			Date:					RT							
QA Closed:			Date:			WORK ORDER NON-	-CC	DNFO	RMANCE / UI		Wo	ork Order up	odate only	AERO	SPACE
· · · · · · · · · · · · · · · · · · ·						DISPOSITION				· · · · · · · · · · · · · · · · · · ·		PARTMENT	<u></u>	. 1	
Work Orde	er: _						. 1			AGAMO		. <i></i>	-		
						Rework			Skid-tube	Crosstube	pe Water Jet			Engineeri	_
Part N	۱o					Scrap		Machining Small Fab					d. Eng. Coor.	Quali	· - 1
						Use-as-is		Thern	noforming	Finishing				Oth	er
NCR N	۱o					Suspected Unapproved			Large Fab	Composite					
Root					Desci	ription of work order update	1	nitial	Action			Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	QC Insp	ector
Design															
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Operator	Ш					,	,								
Offset/Setup	Ш			İ											
Process	Ш														
Supplier	Ш														
Training	Ш														
Transport	Ш														
Unapproved															
							FAI	ULT CA	regory	<u> </u>					
Landi	ng G	ear				General		,				,	_		
	\vdash	Bending				Bend		1	Program			Outside Dim	ensions	Pressure/For	rced
		Centre No	ot Concer	ntric		BOM/Route		Grain			L	Over/Under	tolerance	Set-up	
ı	-	Cracks				Broken/Damage/Defect		Hardwa	are		L	Part Incorred	ct	Temperature	∍/Cure
	Ц	Crimp/Kii	nk/Ripple	/Wave		Burrs	L	Inspect	ion Incomplete/Ur	nqualified	L	Part Lost/Mi	ssing	Weld	
	Cuffs					Contamination	_	4	tions Incomplete/l	Unclear	<u> </u>	Part Moved		Wrong Stock	(Pulled
	Crushing				Countersink		•	ned/off center		-	Positioned V				
	-	Heat Trea				Cut Too Short		Mislabe			L	Power Loss/	Surge	Other	
	-	Inspectio	•	Tube	L	Drawing		Misread							
	Ш	Marks/Ch	natter			Drill Holes		Off-set							
		Turning S	equence			Finish		Out of	Calibration						
		Wave/Tu	ist in Tub	ne .	l	Fit/Function		Out of	Sequence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH